Work Orde November 23, 2											Page 1
Item ID: Revision ID: Item Name:	D3531-1 A Bracket		2	Accept				s s	etup Star Stop		
Start Date: Required Date: Reference:	23/11/2009 02/12/2009	Start Oty: 6.00 Req'd Qty: 6.00	/ 1880 B BUT 1881		Cust Item II Customer:	D:					
Approvals:	Process Pla	ın: <i>Bf</i>	Date:	Tooling: SPC (Y/N):		ite:		F	tun Star Stop	1 1884466 1	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3531	Rev	' A									
Waterjet FLOW CNC Water	iet <i>િલ્લ</i> ્ . જતા		per Dwg D3531 □Dwg Rev:_ f necessary	0.00 0.00 Prog Rev:_ 0.00	A 🗆 2-			18	<u>9-12-</u>	q (q)	
QC Quality Control		Мето		0.00				<u> </u>	9-12-9		- <u></u> -
120 QC Quality Control		QC8- Inspect parts -	second check	0.00	lizio		,	(E)	PTO -	->	

Dart Aerospace Ltd

W/0: 53	3912	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
9/12/10	<u>\$</u> 120	Jude Oby to Part for Que rerespection template	2	orline	184		Soderko			

Part No: <u>D3531-1</u>	PAR #: Fault Category:	NCR: Yes No DQA:	_ Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)										
	Description of NC		Corrective Action Section B	Verification	Approval	Annessal					
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng.	Approval QC Inspector				
				İ							
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng				

November 23, 2009 2:44:13 PM

Item ID: **Revision ID:** D3531-1

Α

Item Name:

Bracket

Start Date:

23/11/2009

Start Qty: 6.00 -

Required Date: 02/12/2009 Req'd Qty: 6.00

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: Date:_____

Tooling: SPC (Y/N): Date:

Draw

Rev.

Plan

Code

Date:

Run

Reject

Qty

Start



Number Stamp

Insp.

Stop

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

QC: _____ Date: ____

Bend as per Dwg D3531

Set Up/ **Run Hours**

0.00

0.00

SB 10/03/22

Accept

Qty

Reject

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8 wester

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Memo

= 0.00 M 10/03/04

{ }

0

Dart	Aero	space	Ltd
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W/O:			RK ORDER CHANGE	S		•		,	
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								,	
Part No: PAR #:		PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	\:	Date: _	
		esolution:	Disposition: QA			losed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCI	7)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip		Section B Sign &		ation	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				
						:			

Work Order ID 53912

Α



Page 3

November 23, 2009 2:44:13 PM

Required Date: 02/12/2009

Item ID: **Revision ID:** D3531-1

Bracket

Accept

Setup Start



Item Name:

Start Date:

23/11/2009

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date: Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

Number 0.00 Bl 10-3-H

Draw

Plan Draw Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location: 258

Memo

0.00

0.00

10-3-4 3



180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/11/XJ MF

Dart Aeros	pace Ltd
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W/O: WORK ORDER CHANGE										•
DATE	STEP	PRO	OCEDURE CHAI	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
							<u> </u>			
Part No: PAR #: _		PAR #:	Fault Cate	ory:	NCF	R: Yes	No DQ .	A:	_ Date: _	
	Res	solution:	Disposition	:	QA:	N/C CI	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)	•		
DATE	STEP	Description of NC	Corrective Action Section B				Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector

Picklist Print

November 23, 2009 2:44:21 PM

Work Order ID: 53912

Parent Item:

D3531-1RevA

Parent Item Name: Bracket

Comments:



Start Date: 23/11/2009

Required Date: 02/12/2009

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No		The state of the s	100	sf	249.0005		3.6		
											1B9-12-9	

6061-T6 .040 Sheet

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	249.0005		
100742	3.3		
102723	5.93		
105842	12		
106747	5.7516		
107461	11.7841		
109396	17.9316		
111224	23.0629		
113004	167.7403		113004
19380	1.5		



Dart Aerospace	Ltd
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Dart Ae	rospace l	Ltd							
W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-, .									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Res	solution:	Dispositio	QA: N/C CI	osed:	Date:	· · · · · · · · · · · · · · · · · · ·		
NCR:			WORK ORDI	ER NON-CONFORMAI	NCE (NCR)			•
DATE	0.750	Description of NC		Corrective Action Section	n B	Varifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	Approval QC Inspector
				•					

DART AEROSPACE LTD	Work Order:	53912	
Description: Bracket	Part Number:	D3531-1	
Inspection Dwg: D3531 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

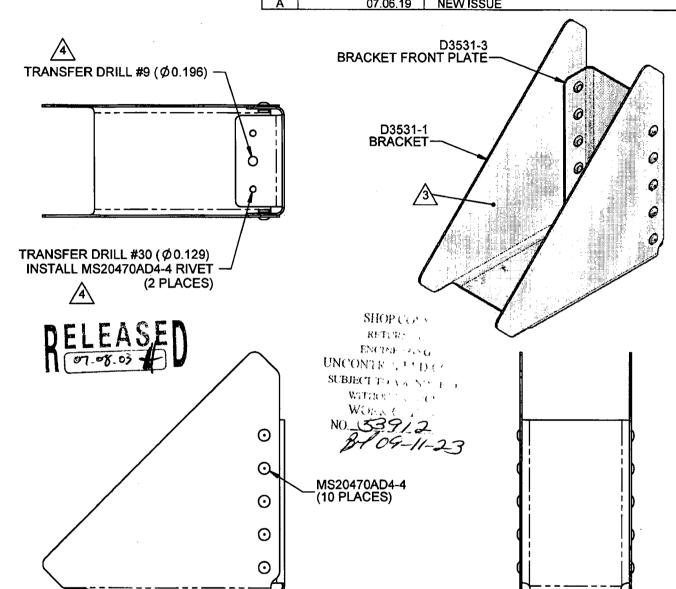
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	,700	×			
Ø0.129	+0.005/-0.001	,133	16			
0.33	+/-0.030	,333	¥			
2.840	+/-0.010	2.840	Ø,			
1.70	+/-0.030	1,700	R			
1.45	+/-0.030	1,455	8			
0.38	+/-0.030	,377	>			
0.19	+/-0.030	188	6			
5.88	+/-0.030	5.883	85			
12.66	+/-0.030	12.66	8			
0.600	+/-0.010	,548	¥			
1.77	+/-0.030	1.11	\			
1.24	+/-0.030	BEND	1.24 2			
,1.16	+/-0.030	BEND				
·						
						,

Measured by:	IR.	Audited by:	Prototype Approval:	N/A
Date:	9-12-9	Date: 08/12/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.10.15	New Issue	KJ/EC/DD	
•			7.0	



DESIGN CB	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	D3531	REV. A SHEET 1 OF 3
07.06.19		BRACKET ASSEMBLY	SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION	



D3531-041 BRACKET ASSEMBLY

NOTES:

1) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 ALL PARTS

2) ASSEMBLE PER DART QSI 003

3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET

ASSEMBLY, WHERE INDICATED
4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE **BEFORE FINISHING**

PARTS LIST

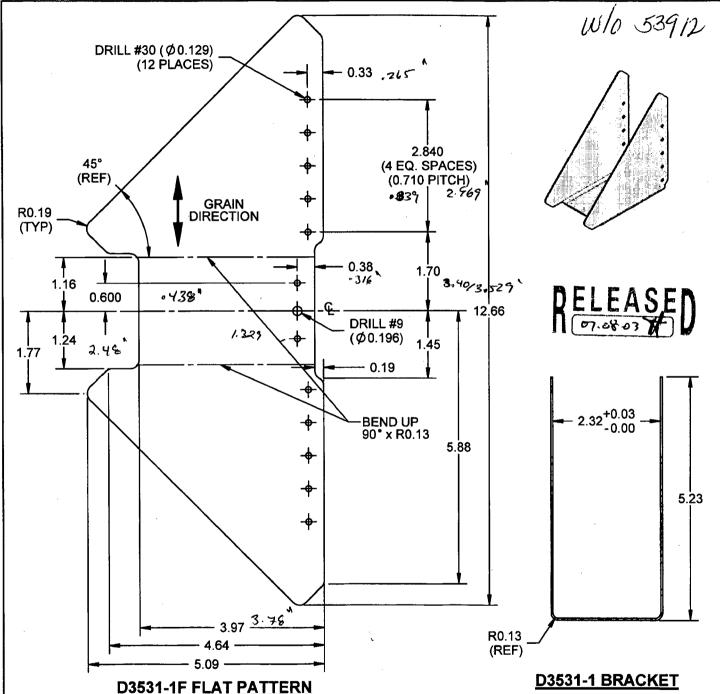
QTY.	P/N	DESCRIPTION			
Х	D3531-041	BRACKET ASSEMBLY			
1	D3531-1	BRACKET			
1	D3531-3	BRACKET FRONT PLATE			
12	MS20470AD4-4	RIVET			

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DESIGN)	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKE	ED_	APPROVED	DRAWING NO.	REV. A
		THE THE	D3531	SHEET 2 OF 3
DATE			TITLE	SCALE
07.06.19		06.19	BRACKET ASSEMBLY	1:2



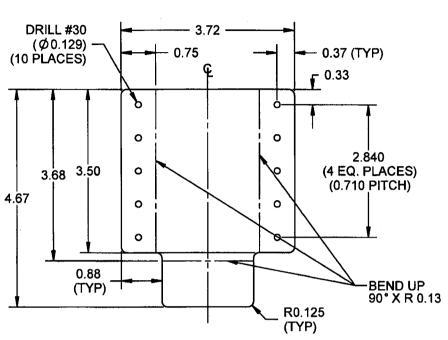
- <u>NOTES:</u>
 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX 6) PART IS SYMMETRIC ABOUT ©

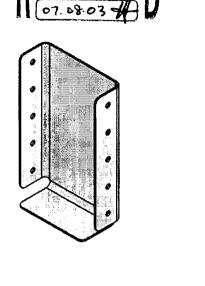
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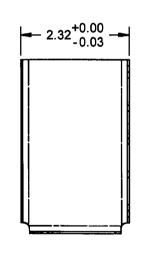


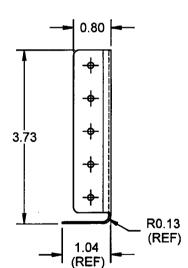
DESIGN CB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	D3531	REV. A SHEET 3 OF 3
07.06.19		BRACKET ASSEMBLY,	SCALE 1:2
		wlo	53912





D3531-3F FLAT PATTERN





D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT &

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